

# Work Order ID 79146

January-20-12 1:44:04 PM

\*79146\*

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4269-7

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID: ~~PRELIM~~

Stop

\*NS2\*

Item Name: Angle

Start Date: 20/01/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 03/02/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/01/20 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4269	<del>PA1</del> <u>A</u> <u>n</u>								
100		0.00							
<b>*100*</b>									
Small Fab	<b>Memo</b>	0.00							
Small Fab	1- Cut to length as per dwg 2- Drill two holes to make R0.25 @ 2 place as per dwg (use 1/2 unibite) 3- Trace and cut angle as per dwg 4- Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*120*</b>									
HandFinish	<b>Memo</b>	0.00							
Hand Finishing									

12/01/24

4

12.01.25 (4)

4 PR 12-1-25

B79031

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79146**

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**\*79146\***

Page 2

Item ID: D4269-7      Accept      **\*N9000040100\***      Setup Start **\*NS1\***  
Revision ID: PRELIM      Stop **\*NS2\***  
Item Name: Angle  
Start Date: 20/01/2012      Start Qty: 4.00      **\*4\***      Cust Item ID:  
Required Date: 03/02/2012      Req'd Qty: 4.00      **\*4\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>200</u>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

**POSITIVE RECALL**EFFECTIVE 12/11/30 AUTH MERELEASED 12-01-27 DATE 12/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-20-12 1:44:08 PM

Page 1

Work Order ID: 79146

\*79146\*

Parent Item: D4269-7

\*D4269-7\*

Parent Item Name: Angle

Start Date: 20/01/2012

Required Date: 03/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A.750X.750X. 063W		Purchased	No			100	f	23.9330	1.836	7.730526			

\*M2024T3A 750X 750X 063W\*

\*\*

Angle2024T3511 .750 x .750 x .063w

Location

Loc Qty

Loc Code

MAT028

23.933

103509

22.164

116909

1.769

7.8 ~~20~~ 12/01/24

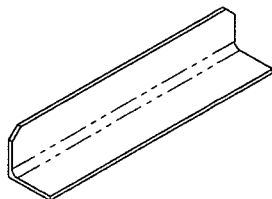
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

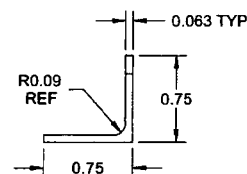
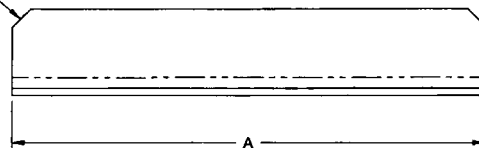
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



0.16 x 45°  
CHAMFER  
2 PL



**D4269-X**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20489-Y	A	WEIGHT
D4269-1	ANGLE	EA20489-33	4.03	0.04
D4269-3	ANGLE	EA20489-30	4.83	0.04

**NOTES:**

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE  
PER QQ-A-200/3  
OR AMS 4152, 4164 & 4165  
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: SEE TABLE

**RELEASED**  
2011-04-06  
WN

A NEW ISSUE		RF		10.11.22
REV.	DESCRIPTION	BY	DATE	
DESIGN	RF			
DRAWN	RF			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	10.11.22			
		<b>DART AEROSPACE LTD</b>		
		HAWKESBURY, ONTARIO, CANADA		
		DRAWING NO. <b>D4269</b>		REV. A
		TITLE <b>VRD PARTS</b>		SCALE
		DATE <b>10.11.22</b>		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

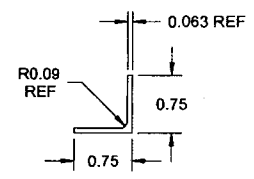
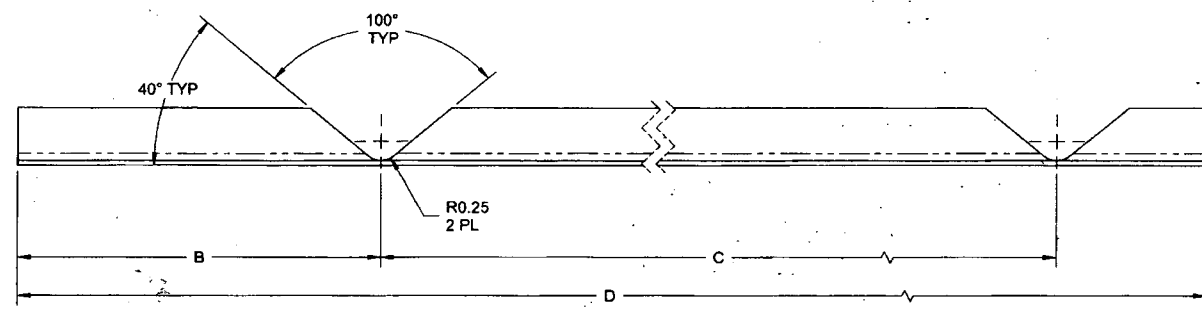
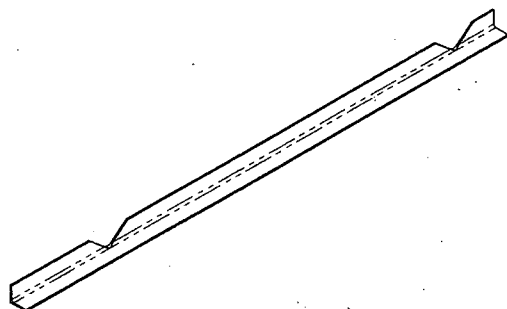
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



79146



**D4269-Z**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D	WEIGHT
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25	0.21
D4269-7	ANGLE	EA20469-32	2.28	16.5	22.03	0.19

- NOTES:**
- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE  
PER QQ-A-200/3  
OR AMS 4152, 4164 & 4165  
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
  - 7) WEIGHT: SEE TABLE

RELEASED  
R 2011-04-05

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4269</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>VRD PARTS</b>	NTS
DATE	10.11.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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